

Date: Monday, 18/08/2008 4:03:23 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 41338
 Estimate Number : 10495
 P.O. Number :
 This Issue : 18/08/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 18/08/2008 Type : MACHINED PARTS
 Previous Run : 39455
 Drawing Name : LITTER TIE DOWN ASS'Y (LOCKING) - UNDER
~~REVIEW~~ *N/A Jml*
 Part Number : D2360
 Drawing Number : D2360/D2341
 Project Number : N/A
 Drawing Revision : D / F
 Material :
 Due Date : 10/09/2008 Qty: 6 Um: Each
 Written By :
 Checked & Approved By : *JUL 08.8-18*
 Comment : est rev H 07.06.12 ech 825 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6201 "T" Extrusion



Comment: Qty.: 1.1067 f(s)/Unit Total: 6.6402 f(s)

Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion)

Batch: *B36793*

Jml 08/09/14

6

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks: 12.65" Long

Jml 08/09/14

6

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio D2341 and Dwg D2341

N.A 08/09/14 DP 08/02/16

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N.A 08/09/14 DP 08/09/16

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

DP 08/09/17

6.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Deburr and Tumble

N/A Jml

DP 08/09/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
2/12/14		2750 SKOT is low because of Vise jaws and Y axis origin						

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 4:03:23 PM
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Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING) - UNDER REVIEW

Job Number: 41338

Part Number: D2360

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

1:00pm

OVEN TEMPERATURE:

326°F

FINISH TIME:

1:30pm

8/9/18 08-09-17

X6

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

D2002015

Knob



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Knob

12.0

D2345

Lock Channel



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Lock Channel

13.0

D2366

Lock Handle



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Inventory

14.0

D2367

Handle Knob



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Inventory

8/9/18

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 4:03:23 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING) - UNDER REVIEW

Job Number: 41338

Part Number: D2360

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

D2372

Quick Release



41426



SP

Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)
Quick Release

16.0

D2373

Spring



(2)
26458

(4)
36922



SP

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
Spring

17.0

D2444

Pip Pin Assembly



41429



SP

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
Pip Pin Assembly

18.0

AN526C1032R18

Screw



4523



SP

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
Screw

19.0

AN960JD10

Washer



104517



SP

Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)
Washer

20.0

AN960JD10L

Washer



105793



SP

Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)
Washer

21.0

MS20470AD34

Rivet, Universal Head



15541



SP

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
Rivet, Universal Head

22.0

MS21042L3

Nut



(15)
103641

(3)
104625



(6x)
SP

Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)
Nut

8/11/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 4:03:23 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING) - UNDER REVIEW

Job Number: 41338

Part Number: D2360

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

MS27039113

Screw



13719



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
Screw

scf

24.0

MS27039115

Screw



108169



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)
Screw

scf

25.0

NAS679A3W

Nut



1463



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
Nut

8/9/18

6x

scf

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per dwg D2360

8/08/09/19 (6)

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/08/09/19 (6)

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

5/1/8x

8/8/19 (6)

29.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/19

Job Completion



MF 08-09-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 41338
Description: Litter Tie Down Bracket (Locking)		Part Number: D2341
Inspection Dwg: D2341	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

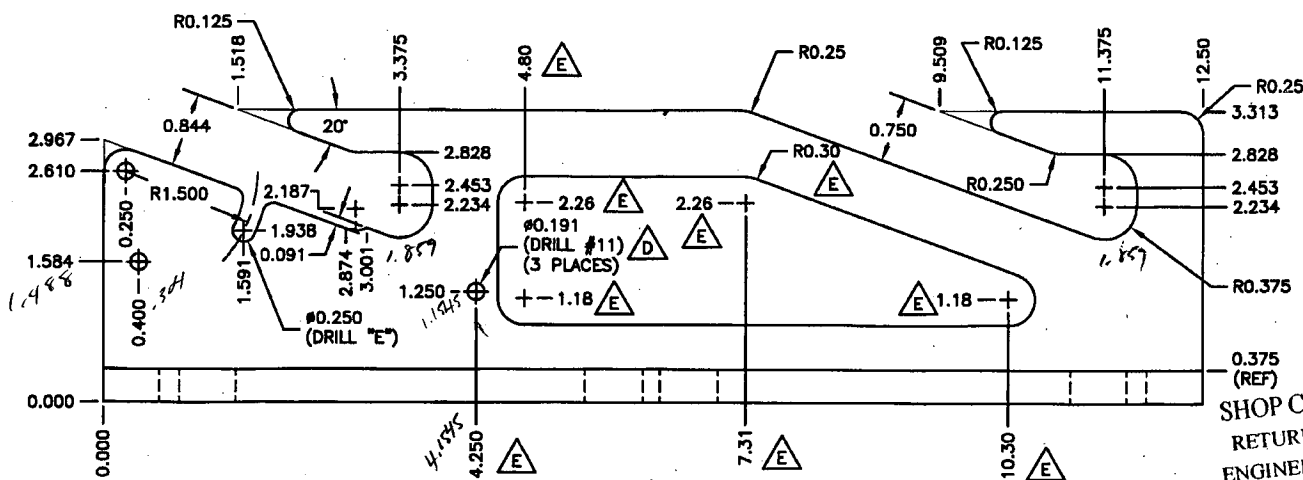
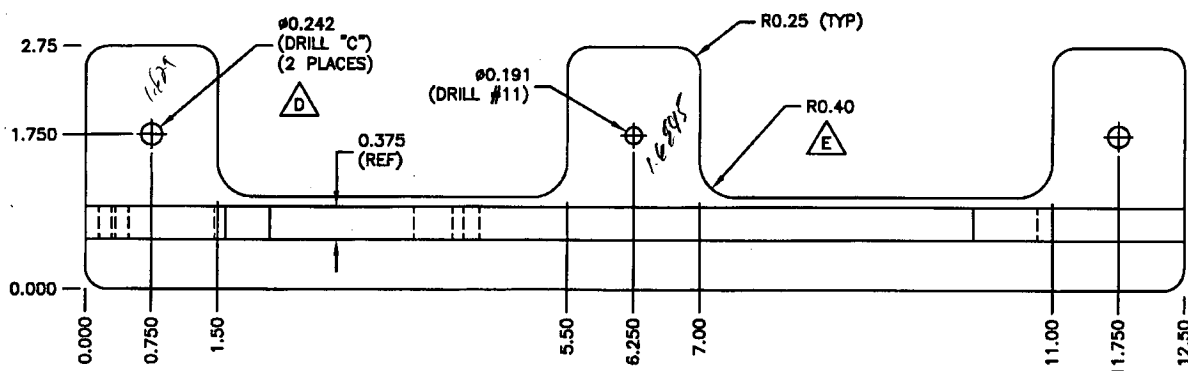
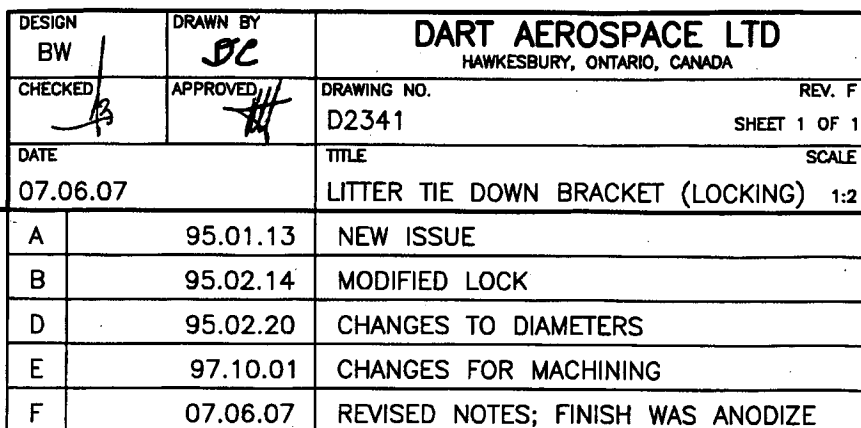
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.500	+/-0.010	1.50				
1.000	+/-0.010	1.00				
Ø0.242	+0.005/-0.001	.242				
Ø0.191	+0.005/-0.001	.191				
R0.250	+/-0.010	R.025				
1.700	+/-0.010	1.700				
0.750	+/-0.010	.750				
2.750	+/-0.010	2.75				
11.000	+/-0.005	11.000				
5.500	+/-0.010	5.500				
1.584	+/-0.010	1.584				
Ø0.191	+0.005/-0.001	.191				
2.610	+/-0.010	2.614				
0.844	+/-0.010	.844				
1.250	+/-0.010	1.250				
0.750	+/-0.010	.750				
12.500	+/-0.010	12.510				
3.313	+/-0.010	3.313				
4.250	+/-0.010	4.250				
0.400	+/-0.010	.400				

Measured by: RG
Date: 08/09/16

Audited by: SP
Date: 08/09/17

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.05.24	New Issue P/O D2360	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	



1) MATERIAL: MAKE FROM D6201-0125 EXTRUSION
(6061-T6 T651 PER QQ-A-200/8)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

3) BREAK ALL SHARP EDGES TO 0.005 TO 0.010

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

6) IDENTIFY WITH DART P/N "D2341" USING FINE POINT
PERMANENT INK MARKER

(REF)
 SHOP COPY
 RETURN TO
 ENGINEERING
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 WITHOUT NOTICE
 BY ORDER

RELEASED WORK ORDER 1133

07.06.22

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DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED [Signature]	DRAWING NO. D2360	REV. D SHEET 1 OF 2
DATE 07.06.06		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS	
A	95.02.10	NEW ISSUE	
B	95.02.20	RE-DESIGN	
C	97.08.27	ADD MS20470AD3-4 RIVET	
D	07.06.06	D2002-015 WAS D2376; SECTION B-B QTY(2) AN960JD10 WAS QTY(3) QTY(8) AN960JD10L WAS QTY(5)	

RELEASED07-06-07 **[Signature]****PARTS LIST:**

QTY	PART NUMBER	DESCRIPTION
X	D2360	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	D2341	LITTER TIE DOWN (LOCKING)
1	D2345	LOCK CHANNEL
2	D2366	LOCK HANDLE
1	D2367	KNOB (DELIN)
2	D2372	QUICK RELEASE FASTENERS
1	D2373	SPRING
2	D2002-015	KNOB (DELIN)
1	D2444	PIP PIN
1	AN526C1032R18	SCREW
2	AN960JD10	WASHER
8	AN960JD10L	WASHER
1	MS20470AD3-4	RIVET
3	MS21042L3	NUT (OR MS21042-3)
1	MS27039-1-13	SCREW
2	MS27039-1-15	SCREW
1	NAS679A3W	NUT



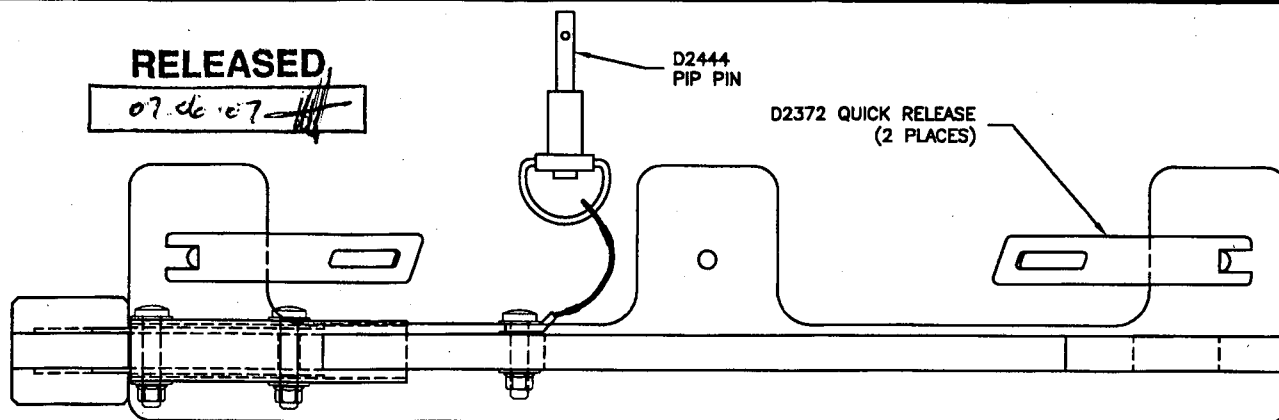
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WORK ORDER
NO. **41338**

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DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED #	DRAWING NO. D2360	REV. D SHEET 2 OF 2
DATE 07.06.06		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS	SCALE

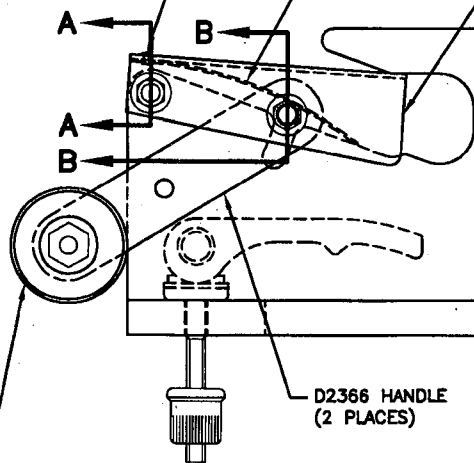


MS20470AD3-4
(INSTALL IN FIRST
HOLE FROM EDGE)

D2373 SPRING

D2345 LOCK CHANNEL

D2341 LITTER TIE
DOWN (LOCKING)



AN526C1032R18 SCREW
D2002-015 KNOB
D2366 HANDLE (REF)
D2367 KNOB
D2366 HANDLE (REF)
D2002-015 KNOB
AN960JD10L WASHER
NAS679A3W NUT

D2366 HANDLE
(2 PLACES)

MS27039-1-13 SCREW
AN960JD10L WASHER
D2444 PIP PIN (REF)
AN960JD10L WASHER
D2341 LITTER TIE DOWN (REF)
AN960JD10L WASHER
MS21042L3 NUT

D2360 LITTER TIE DOWN ASSEMBLY (LOCKING)

D2345 LOCK
CHANNEL (REF)

D2373 SPRING
(REF)

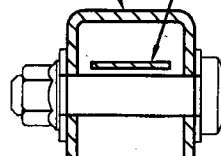
D2341 LITTER TIE
DOWN (LOCKING)

SECTION A-A
(SCALE 1:1)

MS27039-1-15 SCREW
AN960JD10L WASHER
D2345 LOCK CHANNEL (REF)
AN960JD10 WASHER
D2341 LITTER TIE DOWN (REF)
AN960JD10 WASHER
D2345 LOCK CHANNEL (REF)
AN960JD10L WASHER
MS21042L3 NUT

D2345 LOCK
CHANNEL (REF)

D2373 SPRING
(REF)



MS27039-1-15 SCREW
AN960JD10L WASHER
D2345 LOCK CHANNEL (REF)
AN960JD10L WASHER
MS21042L3 NUT

SECTION B-B
(SCALE 1:1)

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8.15